

Date: Monday, 11/21/2005 7:46:37 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 24932		
Estimate Number	: 10721		
P.O. Number	: N/A	Part Number	: D34637
This Issue	: 11/21/2005 S.O. No. : N/A	Drawing Number	: D3463 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 11/28/2005 Qty: 2 Um: Each
Checked & Approved By	: <u>See comment below</u>		
Comment	: EST REV> A 05.11.18 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	Inventory
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Comment: Qty.: 1.0000 f(s)/Unit Total: 2.0000 f(s)
 AISI 304 SS seamless tubing 0.750 OD X 0.120 wall
 (M304TR0750W120)
 Batch: M18497

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Remove punch pins for hole, punch profile as per dwg D3463 using DT8313
 2-Drill hole as per dwg D3463
 3-Deburr
 4-Bend end as per dwg D3463

SB 05/11/22

SB 05/11/22

SB 05/11/22

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

EC 05.11.22

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1-Mill as per dwg D3463
 2-Deburr

EC 05.11.22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/11/22	20	2 pieces were Too short		Scrap destroy				

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

05/11/22

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

05/11/23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

05/11/23

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

05/11/24

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

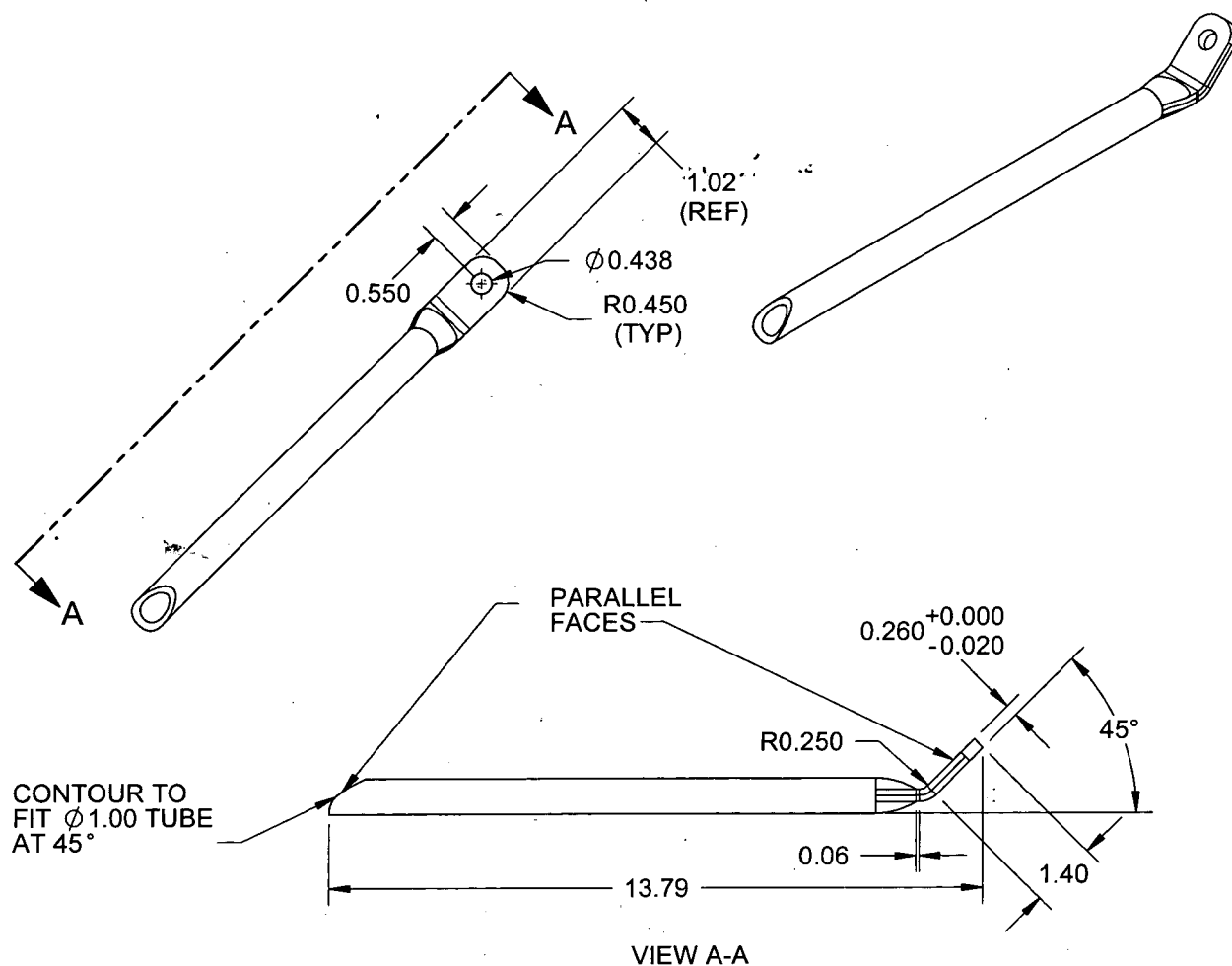
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3463	REV. A SHEET 3 OF 4
DATE 05.09.20	TITLE STEP WELDMENT		SCALE 1:4



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS 0.750 x 0.120 WALL ROUND TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKER SHARP EDGES 0.005 TO 0.010

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